

Work Order ID 76264

76264

Page 1

Tuesday, November 08, 2011 1:23:52 PM

Item ID: D3508-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate
Start Date: 11/8/2011 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/22/2011 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: M.L.J Date: 11/11/08 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3508	Rev C								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3508 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

364.640

11-11-10

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

11-11-10

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Deliver

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE	0.00				10			
Brake NC	Memo 1-Form on brake using DT8326 and DT8261 as per Dwg D35082-Form joggle as per Dwg D3508 Using DT8158	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				710			
Quality Control	Memo	0.00							
150 *150* Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo START TIME: 8:00 OVEN TEMPERATURE: FINISH TIME: 8:30	0.00							

m 118489

320°F

8:30

10x0 m-f 11/11/15

W/O:		WORK ORDER CHANGES					
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Required Date: 11/22/2011 Req'd Qty: 10.00 ***10*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>FP-1</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

10 x d 11/11/15
COUNTED & MEASURED

10X Ø M-L 11/11/15

11/11/15

11-11-15
(10)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, November 08, 2011 1:23:57 PM

Page 1

Work Order ID: 76264

76264

Parent Item: D3508-3

D3508-3

Parent Item Name: Wearplate

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	285.8795	0.734	7.726316			

M304S20GA

304/316 .040 Sheet

IB/HI-10

Location

Loc Qty

Loc Code

MAT020

285.8795

116623

0.2

117550

4.363

117933

27.3442

118400

25.6723

118964

36.5

119346

191.8

119346

(10)

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DART AEROSPACE LTD		Work Order:	76264
Description: Wearplate		Part Number:	D3508-3
Inspection Dwg: D3508	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.070	2		V B02	
2.813	+/-0.010	2.811	2		V	
0.375	+/-0.010	.377	2		V	
5.625	+/-0.010	5.625	2		T B01	
33.750	+/-0.010	33.750	2		T	
37.13	+/-0.030	37.13	2		T	
Ø0.188	+0.005/-0.001	.189	2		V	
0.300	+/-0.010	.300	2		V	
0.300	+/-0.010	.303	2		V	
0.038	+/-0.010	.034	2		V	

Measured by: R	Audited by: S	Prototype Approval:	N/A
Date: 11-11-10	Date: 11/11/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	DD

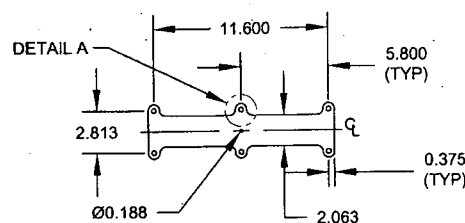
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

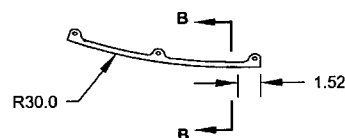
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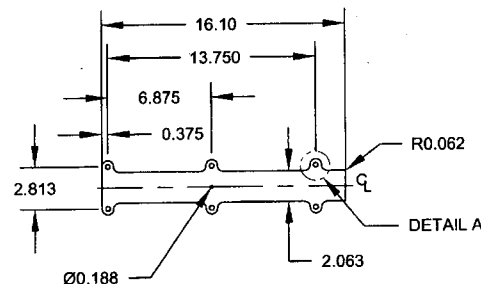
NOTE: Date & initial all entries



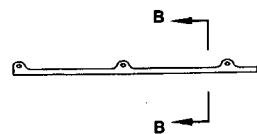
D3508-1 FLAT PATTERN



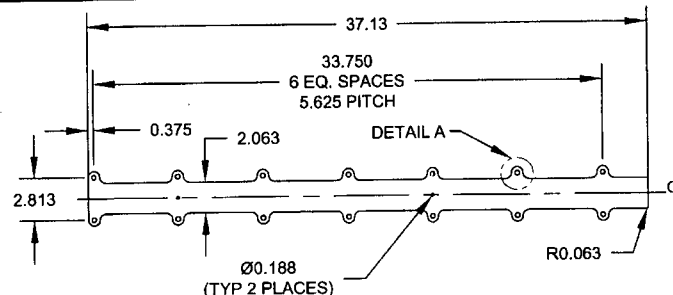
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



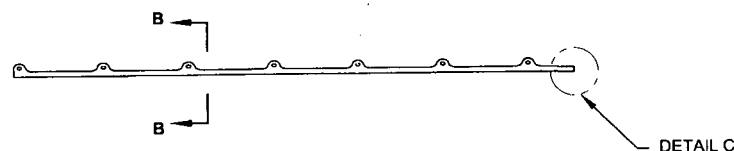
D3508-7F FLAT PATTERN



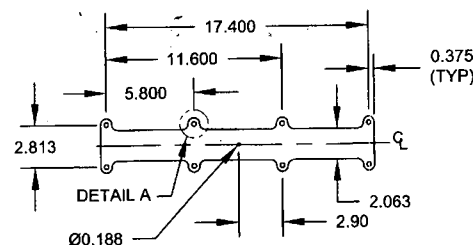
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(MAKE FROM D3508-7F)



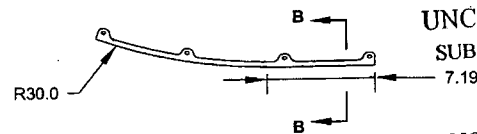
D3508-3 FLAT PATTERN



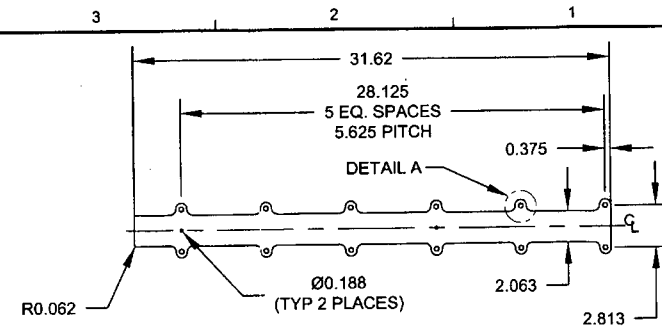
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



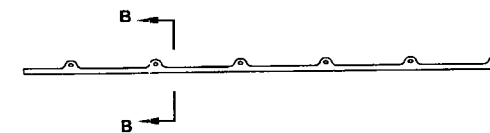
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK UNDER

NO. 76264

11-11-05

C	ADD -9/11-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.20		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3508
REV. C
SHEET 1 OF 2

TITLE WEARPLATE
SCALE 1:8

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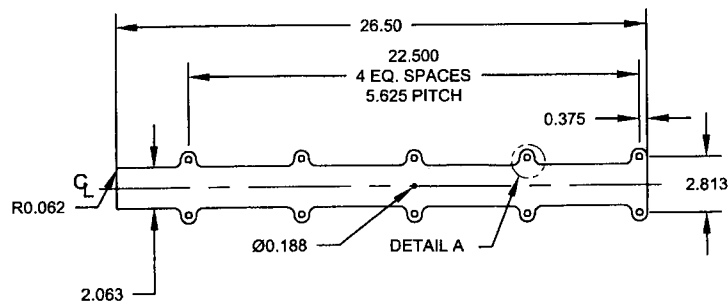
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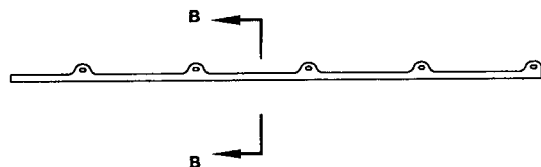
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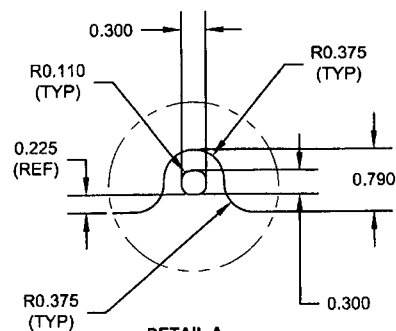
NOTE: Date & initial all entries



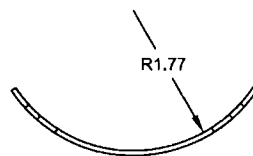
D3508-11F FLAT PATTERN



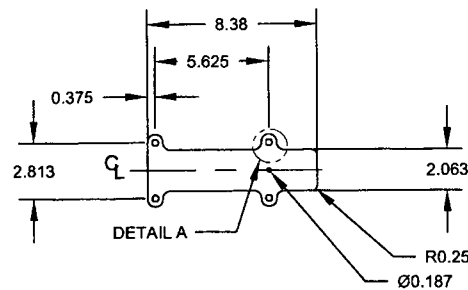
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



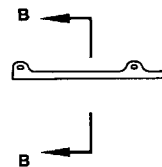
DETAIL A
(SCALE 2:3)



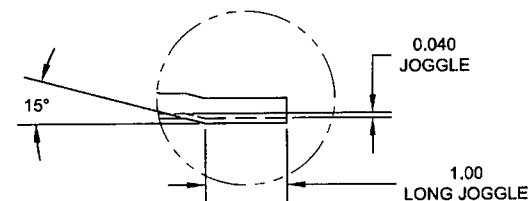
SECTION B-B
(SCALE 2:3)



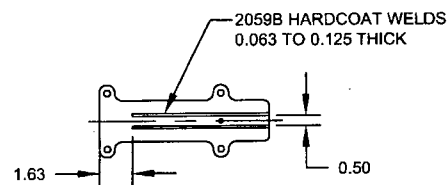
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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